

Date: Wednesday, 9/27/2006 11:07:59 AM
User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CREW WINDOW		
Job Number	: 28670					
Estimate Number	: 11326					
P.O. Number	: N/A		Part Number	: D33171		
This Issue	: 9/27/2006	S.O. No. : N/A	Drawing Number	: D3317 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: 9/26/2006	Type : PURCHASED PARTS	Drawing Revision	: A		
Previous Run	: 28670		Material	: N/A		
Written By			Due Date	: 10/3/2006		
Checked & Approved By			Qty:	4	Um:	Each
Comment	: Est. A 05.03.22 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-26 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MACRLICS125	1/8" Polycast II Sheet
Comment: Qty.: 4.4069 sf(s)/Unit Total : 17.6274 sf(s) 1/8" Polycast II Sheet Batch: M100124 <i>M 06 09 26</i>		
2.0	WATER JET	FLOW WATER JET
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs FLOW WATER JET 1-Cut as per Dwg D3317 Dwg Rev: <i>A</i> <i>M 06 09 27</i> Prog Rev: <i>A</i>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06 09 27</i> <i>(4)</i>		
4.0	QC8	SECOND CHECK
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs SECOND CHECK <i>J 06-09-23</i> <i>(4)</i>		

Date: Wednesday, 9/27/2006 11:07:59 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CREW WINDOW

Job Number: 28670

Part Number: D33171

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

SMALL & MEDIUM FAB RESOURCE 1

Engrave part# and batch# per dwg D33171

SB 06/09/27

(4)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT WORK TO CURRENT STEP

206-09-27
④

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: _____

206-09-27
④

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

FINAL INSPECTION/W/O RELEASE

206-09-27
④

Job Completion



206-09-27
④

Date: Tuesday, 26/09/2006 10:04:57 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CREW WINDOW	
Job Number : 28670		
Estimate Number : 11326		
P.O. Number :	Part Number : D33171	
This Issue : 26/09/2006 S.O. No. :	Drawing Number : D3317 REV A	
Prsht Rev. : NC	Project Number : N/A	
First Issue : // Type : PURCHASED PARTS	Drawing Revision : A	
Previous Run : 28670	Material :	
Written By : <u>L</u>	Due Date : 03/10/2006 Qty: 4 Um: Each	
Checked & Approved By :		
Comment : Est. A05.03.22 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-26 JLM		
Additional Product		
Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	MACRLICS125	1/8" Polycast II Sheet 
Comment: Qty.: 4.4069 sf(s)/Unit Total : 17.6274 sf(s) 1/8" Polycast II Sheet Batch: 21100724 M1 a 09 26		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3317 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary		 <u>(4)</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>M 06 09 27</u>		 <u>(4)</u>
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK <u>J 06 09 27</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

Date: Tuesday, 26/09/2006 10:04:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CREW WINDOW

Job Number: 28670

Part Number: D33171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Date: Wednesday, 9/20/2006 3:23:46 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CREW WINDOW		
Job Number	: 28670					
Estimate Number	: 11326					
P.O. Number	:		Part Number	: D33171		
This Issue	: 9/20/2006	S.O. No. :	Drawing Number	: D3317 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type :	Drawing Revision	: A		
Previous Run	:		Material	:		
Written By	:		Due Date	: 9/27/2006 Qty: 4 Um: Each		
Checked & Approved By	:		<i>KJ 06 09 20</i>			
Comment	:		Est. A05/03/22 New issue KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: _____ Manufacture D3317-1as per Dwg D3317 Possible Supplier: Canus Material release note is required
2.0	D33171P	Crew Window, R22
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Crew Window, R22
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/20/2006 3:23:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CREW WINDOW

Job Number: 28670

Part Number: D33171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

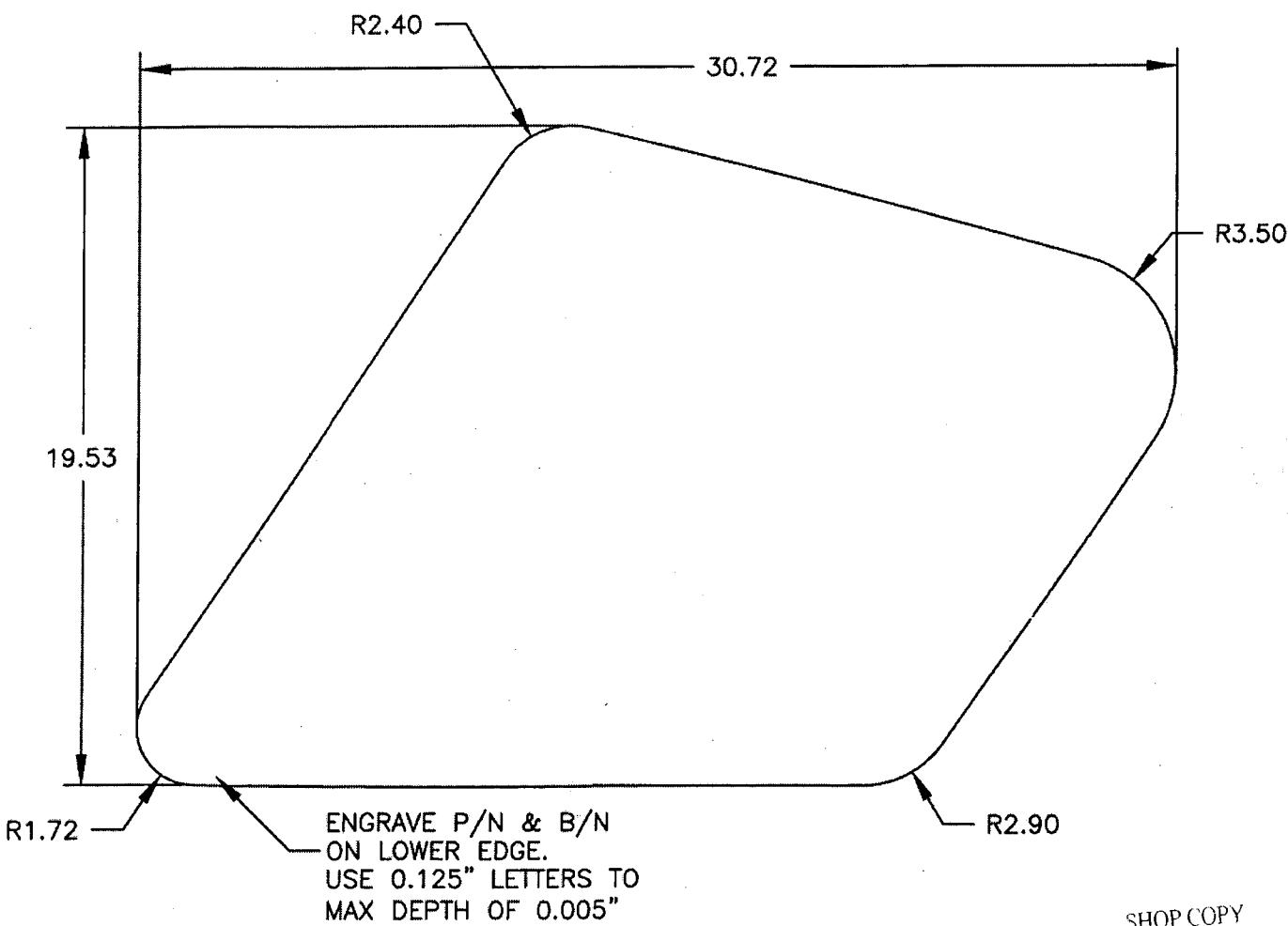
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>IP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3317	REV. A	SHEET 1 OF 1
DATE 04.09.26		TITLE CREW WINDOW (R22)	SCALE 1:5	
A	04.09.26	NEW ISSUE		

RELEASED
05.03.18 - *H***D3317-1 WINDOW**

- 1) CUT PER TEMPLATE D3317-1T1
- 2) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.125 THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WORK ORDER
NO. *28670*

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DART AEROSPACE LTD	Work Order:	28670
Description:	Part Number:	D3317-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>M. M.</u>	Audited by:	<u>J.</u>	Prototype Approval:	
Date:	06.09.27	Date:	06.09.27	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	